

Date: Tuesday, 9/26/2006 2:39:57 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : OH-58 STEP ASSY LH \*UNDER REVIEW\*\*  
 Job Number : 28722  
 Estimate Number : 12438  
 P.O. Number : N/A Part Number : D058677011  
 This Issue : 9/26/2006 S.O. No. : N/A Drawing Number : D2943 UNDER REVIEW OR  
 Prsht Rev. : NC Project Number : N/A 28 06.09.26  
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : UNDER REVIEW B  
 Previous Run : 28393 Material : N/A  
 Written By : Due Date : 10/10/2006 Qty: 3 Um: Each  
 Checked & Approved By : 06 09 26  
 Comment : Est Rev: B 01.04.11 Combined with D2943-041 EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD058-677-011 CHG 001 RS 06-10-03 (3)

2.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)  
 Extrusion D2622-120C  
 Batch: 327077 = 1 328215 = 2

PE. 06.10.12 3

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)  
 D2734 206 Step Endplate  
 Batch: 327281

PE. 06.10.12 3

4.0 D2725 206 Step Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)  
 D2725 206 Step Lug  
 Batch: 320783

PE. 06.10.12 3

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2943-1 from D2622 extrusion as per Dwg D2943

PE. 06.10.12 3

2-Deburr and bevel ends for welding

PE. 06.10.13 3

3-Weld end cap(1) and plate as per Dwg D2943 using Jig DT 8482

PE. 06.10.13 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 9/26/2006 2:39:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY LH \*UNDER REVIEW\*\*

Job Number: 28722

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R AL ROD

Batch:

~~101828~~ M18838

M19612

4-Grind end cap welds flush as per dwg D2943

FE. 06.10.13 3  
FE. 06.10.14 3

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

FE. 06.10.16 3

DA 06/10/16 (3)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

06/10/06  
10/16/06

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FE. 06.10.17 3

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld last end cap(1) as per Dwg D2943 using Jig DT 8482

A/R AL ROD

Batch:

M18838

2-Grind end cap welds flush as per dwg D2943

FE. 06.10.17 3

FE. 06.10.17 3

10.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

FE. 06.10.17 3

DA 06/10/18 (3)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Chemical Conversion Coat as per QSI 005 4.1

FC 06 10 19 (3)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06 10 19 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 9/26/2006 2:39:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY LH \*UNDER REVIEW\*\*

Job Number: 28722

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2943 and QSI 005 4.4

Batch: 102098

FL 06 10 23

(B)

14.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

10/1/07 (8)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

16.0

D27311

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Mounting Lug

Batch: 1320613 -

17.0

D27313

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Mounting Lug

Batch: 1320614 -

18.0

D27315

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Mounting Lug

Batch: 1322591 -

19.0

D27317

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Mounting Lug

Batch: 1325452 3M -

1328077 3M -

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 9/26/2006 2:39:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY LH \*UNDER REVIEW\*\*

Job Number: 28722

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bolt

Batch: M100243 -

21.0

AN412A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 24.0000 Each(s)

Bolt

Batch: M101390 2/mcp M100029 3mcp

22.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 36.0000 Each(s)

Nut

Batch: M19099

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Do58-677-011

Location:

PPP Rev: B

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C 06/10/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

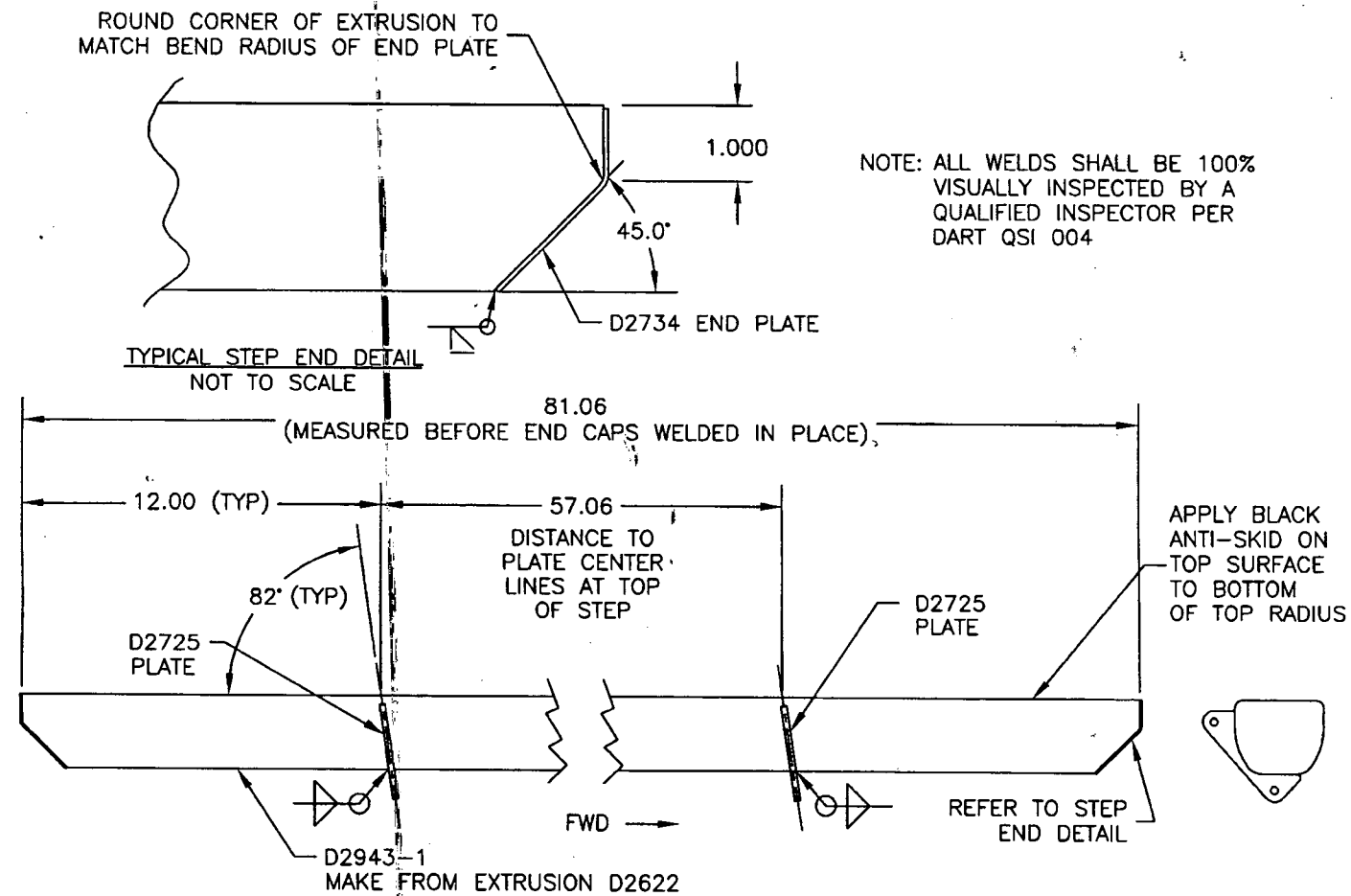
**NOTE:** Date & initial all entries





DESIGN	RF	DRAWN BY	RF	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.11.14	DRAWING NO.	D2943	REV. B
		TITLE	OH-58 STEP ASSEMBLY	SHEET 1 OF 1
				SCALE
				NTS
	A	99.11.19	NEW ISSUE	
	B	05.11.14	UPDATE FINISHING NOTE	

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



D2943-041 LH STEP ASSEMBLY (SHOWN)  
D2943-042 RH STEP ASSEMBLY (OPPOSITE)

**D2943-041/-042 OH-58 STEP ASSEMBLY PARTS LIST**

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2943-041	LH STEP ASSEMBLY
	X	D2943-042	RH STEP ASSEMBLY
1	1	D2622-082*	EXTRUSION
2	2	D2725	PLATE
2	2	D2734	END PLATE

\*out per drawing

**D2943-041/-042 OH-58 STEP ASSEMBLY NOTES**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28722

RELEASED  
05.11.28-140

UNDER REVIEW  
06.03.29  
06.09.26  
06.09.26  
06.09.26

Date: Thursday, 26/10/2006 11:35:40 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D058-677-011/-012
Job Number	: 29185	Part Number	: Z_CUSTOM
Estimate Number	: 10804	Drawing Number	: ADD MISSING HARDWARE
P.O. Number	: <i>N/A</i>	Project Number	: <i>N/A</i>
This Issue	: 26/10/2006 S.O. No. : <i>N/A</i>	Drawing Revision	: <i>N/A</i>
Prsht Rev.	: NC	Material	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : OVERHEAD	Due Date	: 02/11/2006 Qty: 8 Um: Each
Previous Run	: 00015		
Written By	: _____		
Checked & Approved By	: <i>[Signature]</i>		
Comment	: _____		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 REMOVE AND QUARANTINE:  
 D058-677-011 B *1528722*  
 D058-677-012 B *28723*

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 ADD TO EACH KIT  
 12 X AN960JD416 WASHER B *M102339*

3.0	AN960JD416	Washer
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Comment: Qty: 12.0000 Each(s)/Unit Total: 96.0000 Each(s)  
 Washer *M102339*

4.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 REPACKAGE PER PPP